

What is Claimed is:

1. A lawn edging comprising:
a plurality of middle blocks and two end blocks,
each middle block being disposed between and connected to two other middle
5 blocks or one other middle block and one of the end blocks by a living hinge,
each middle and end block including an upper portion and a lower portion,
each upper portion including a front face comprising a three-dimensional texture, each
lower portion being tapered.
- 10 2. The lawn edging of claim 1 wherein the lower portion of each block
further includes two side edges that extend inwardly towards each other as they
extend downward from the upper portion, the lower portion further including a front
face and the rear face, at least one of the front or rear faces of the lower portion
including a barbed rib.
- 15 3. The lawn edging of claim 1 wherein the middle and end blocks are
hollow.
4. The lawn edging of claim 1 wherein the lawn edging is fabricated by a
20 continuous vacuum forming process.
5. The lawn edging of claim 1 wherein the living hinges permit two
adjacent blocks to be positioned at an angle with respect to each other ranging from
about 180° to about 90°.
- 25 6. The lawn edging of claim 1 wherein the blocks are hollow except for a
pressure equalization hole.
7. The lawn edging of claim 1 wherein the blocks and living hinges are
30 formed from two or more plastic materials.

8. The lawn edging of claim 1 wherein the blocks and living hinges are fabricated from one or more plastic materials are selected from the group consisting of linear low density polyethylene, polyvinylchloride, polyethyleneterephthalate, polypropylene and mixtures thereof.

5

9. The lawn edging of claim 1 wherein the lower portion of each block further includes two side edges that extend inwardly towards each other as they extend downward from the upper portion to form a point, the lower portion further including a front face and the rear face, the front and rear faces of the lower portion of each block extending towards each other to define a tapered lower edge.

10. A method of fabricating a lawn edging, the method comprising:
providing a plurality of openable and closable mold segments arranged end to end along a continuous path, each mold segment providing a mold for a block of the lawn edging;

15 circulating a plurality of mold segments through multiple revolutions of the continuous path such that the mold segments are closed while traveling along a molding section of the continuous path;

20 continuously extruding a molten stream of plastic at an upstream end of the molding section and into mold cavities of the closed or closing mold segments;

applying a pressure differential to the mold cavities of the closed mold segments to conform the molten stream of plastic to the mold cavities;

25 ejecting a continuous train of inter-connected blocks to a downstream end of the molding section, the blocks being inter-connected by flashing material that serves as living hinges for inter-connecting the blocks together; and

separating a discrete set of lawn edging blocks from the continuous train by cutting the living hinge between two blocks.

11. A method according to claim 10, further comprising the step of cooling the inter-connected blocks.

12. A method according to claim 11, wherein the stop of cooling is performed on the continuous train of inter-connected blocks.

13. A method according to claim 11, wherein the step of cooling is performed on the discrete set of lawn edging segments after the step of separating.

14. A method according to claim 11, wherein the step of cooling includes
5 passing the continuous train of inter-connected blocks through a water bath.

15. A method according to claim 10, wherein the step of providing a plurality of mold segments further comprises a plurality of operable and closable mold segment pairs.
10

16. A method according to claim 15, wherein the step of circulating further comprises circulating the mold segment pairs around at least one continuous track through a plurality of revolutions, and wherein the plurality of mold segment pairs are closed while in the molding section and opened when not in the molding section
15 during each revolution.

17. A method according to claim 16, wherein the mold segment pairs are carried on a pair of adjacent continuous tracks circulating in opposite directions, one mold segment of each pair carried on a respective one of the pair of tracks, and
20 wherein the pair of tracks are arranged generally in the same plane which is generally parallel to horizontal.

18. A method according to claim 10, wherein the step of extruding further comprises extruding multiple streams of molten plastic concentric to one another to
25 form multi-layered blocks and living hinges.

19. A method according to claim 18, wherein the step of extruding further comprises extruding at least two different molten plastic material streams.

20. A method according to claim 18, wherein the step of extruding further comprises extruding at least two different color molten plastic material streams.
30

21. A method according to claim 10, wherein the step of applying a pressure differential further comprises applying a negative pressure to mold cavity surfaces within the mold cavities when in the molding section.

5 22. A method according to claim 21, wherein the step of applying a pressure differential further comprises applying a positive pressure within the stream of molten plastic when in the molding section.

10 23. A method according to claim 10, wherein the step of circulating further comprises coupling a plurality of mold segment pairs to at least one circuitous track, and circulating the at least one circuitous track through multiple revolutions to sequentially close and open the plurality of mold segment pairs at least once during each revolution.

15 24. A method according to claim 23, wherein the step of circulating opens and closes the plurality of mold segment pairs in a clam-shell manner.

20 25. A method according to claim 16, wherein the step of circulating further comprises coupling each mold segment of the plurality of mold segment pairs to a respective track of a pair of circuitous tracks, the pair of tracks arranged generally parallel to one another in the same horizontal or vertical plane, and circulating each of the pair of circuitous tracks in opposite directions to sequentially close and open the plurality of mold segment pairs.

25 26. A method according to claim 10, further comprising the steps of:
re-opening the closed mold segments at a downstream end of the molding section; and
discharging the continuous train of inter-connected blocks from the mold segments during the step of re-opening.

30 27. A method according to claim 10, wherein the mold segments define mold cavities that are non-identical to produce a continuous train of different inter-connected blocks.

28. A method according to claim 10, wherein the step of applying a pressure differential further comprises applying a vacuum to each of the discrete mold cavities of the closed mold segments.

- 5 29. A lawn edging comprising a discrete set of inter-connected blocks made in accordance with the method of claim 10.